

Ship July 30

Dart Aerospace Ltd.

Date: Wednesday, 7/11/2007 2:45:25 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, LH (FOLDING)
 Job Number : 33462
 Estimate Number : 10813
 P.O. Number : N/A Part Number : D412630031
 This Issue : 7/11/2007 S.O. No. : N/A Drawing Number : D412-630 REV. K, P19
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : JK
 Previous Run : 32081 Material : N/A
 Due Date : 7/31/2007 Qty: 2 Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

07.07.25 KS.

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

MF 07-07-25 (2)

3.0

D3463041

Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-041	Step weldment	33480

B 33477 x 2mx

MF 07-07-25

4.0

D3443043

Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	33492

B 33492 x 2mx

MF 07-07-25

5.0

D3443041

Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	33477

B 33477 x 2mx

MF 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	<u>B 30228</u>

MF 07-07-25

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	<u>m103248</u>
	A/R MS20995c41	Lockwire	<u>m101537</u>

MF 07-07-25

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C14	BOLT	<u>m103248</u>

MF 07-07-25

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	<u>B 30225</u>

MF 07-07-25

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	<u>m103641</u>

MF 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	<u>m102073</u>

MF 07-07-25

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	<u>B28171</u>

MF 07-07-25

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	<u>B30308</u>

MF 07-07-25

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	<u>m103286</u>

MF 07-07-25

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	<u>m16941</u>

MF 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs****

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3454-1	Bushing

Batch

B3332304

50

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-3	Bushing

Batch

B28331

50

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-5	Bushing

Batch

B28533

50

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description
6	D3455-1	Spacer

Batch

B28171

2/2/2550

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3455-3 Spacer

Batch

(2) 1027789 ✓ SQ 281774 ✓

23.0

D3462041

Bracket Assmbly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3462-041 Bracket ass'y

Batch

*

2 33478 ✓

24.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN310-4 Nut

Batch

1105059 ✓ SQ

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN310-5 Nut

Batch

1 19096 ✓ 3 102073 ✓ SQ

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-C5A Bolt

Batch

3 1101189 ✓ 3 1100186 ✓ SQ

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

Batch

1102998 ✓ 7/7/25 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN44-C12 Eyebolt

28.0 AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M103248 ✓ SP ✓

29.0 AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M103248 ✓ SP ✓

30.0 AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M104395 ✓ SP ✓

31.0 AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M101064 ✓ SP ✓

32.0 AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M17697 ✓ 3/7/25 SP ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description
f1 3 MS21043-3 Nut

Batch

M104679 ✓

SP

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description
2 MS24665-227 COTTER PIN

Batch

M102073 ✓

SP

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description
2 MS24665-229 COTTER PIN

Batch

M19096 ✓

SP

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description
1 NAS1515H5 Washer

Batch

M105057 ✓

6/17/25 SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location: _____

PPP Rev: _____

A 6/17/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/31

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:45:26 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 33462

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

Done 7/31

Job Completion



U 8-8-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

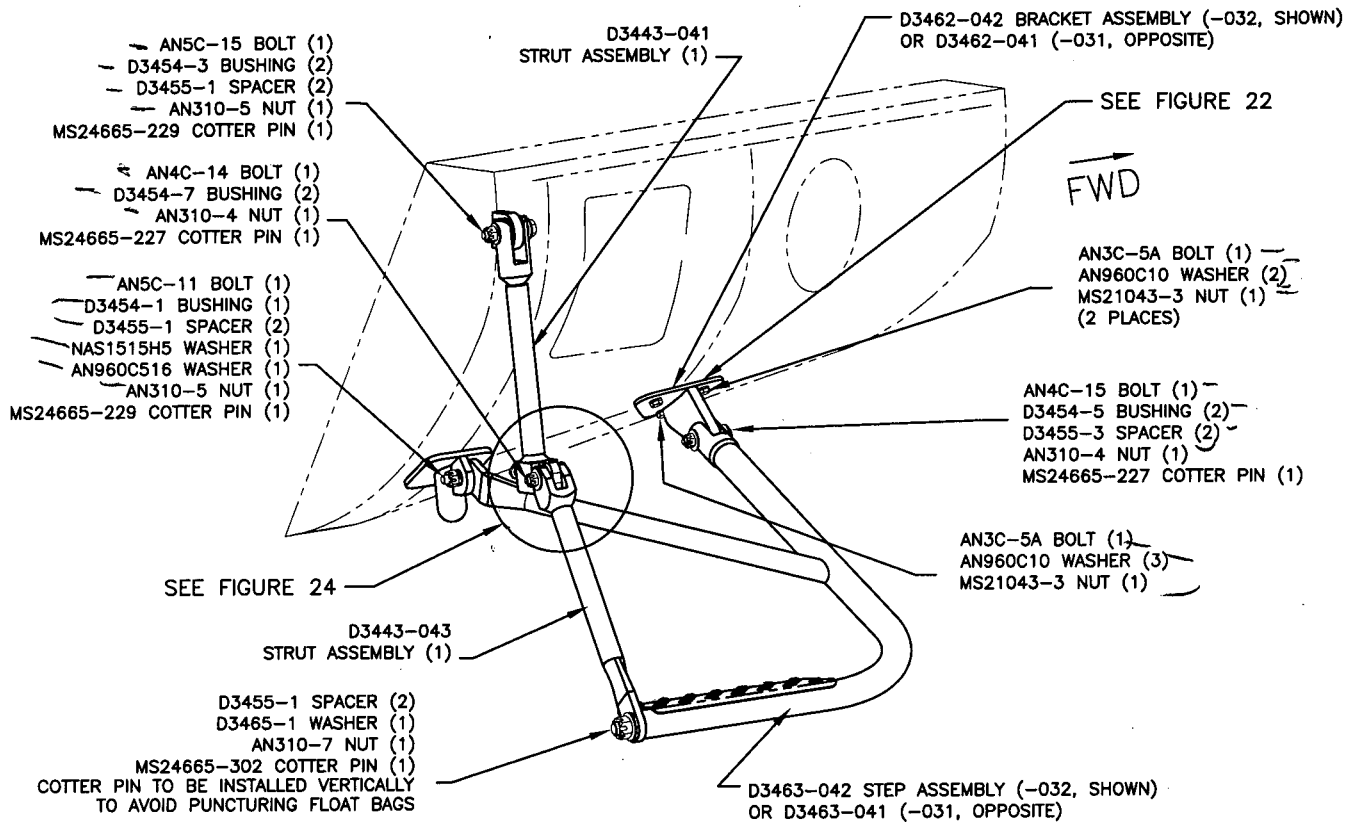
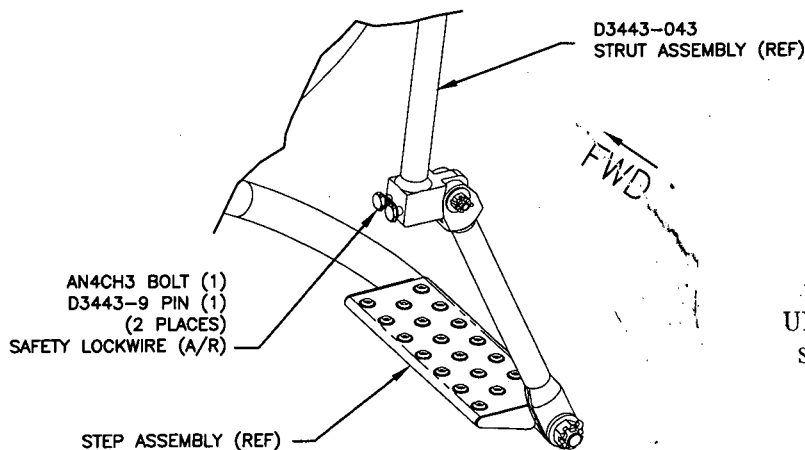


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33462